

Work Order ID 121820

Tuesday, September 30, 2014 10:52:21 AM

ASAP
121820

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Item ID: D3285-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 7/2/2014 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 7/2/2014 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: MJS Date: 10-07-09 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3285	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3285								
<i>6061.080</i>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>18</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

(30) 12/14/10/09

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(30) 14-10-10
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

30 9 BE-14-10-14

14/10/15

14-10-14

Picklist Print

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Parent Item: D3285-1

D3285-1

Parent Item Name: Cap

Start Date: 7/2/2014

Required Date: 7/2/2014

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP A04.07.14New issueKJ/JLM
IPP Rev:B Now on Waterjet 07-03-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	308.4760	0.1527	4			

M6061T6S 080

6061-T6 .080 Sheet

**

Dec 14/10/09

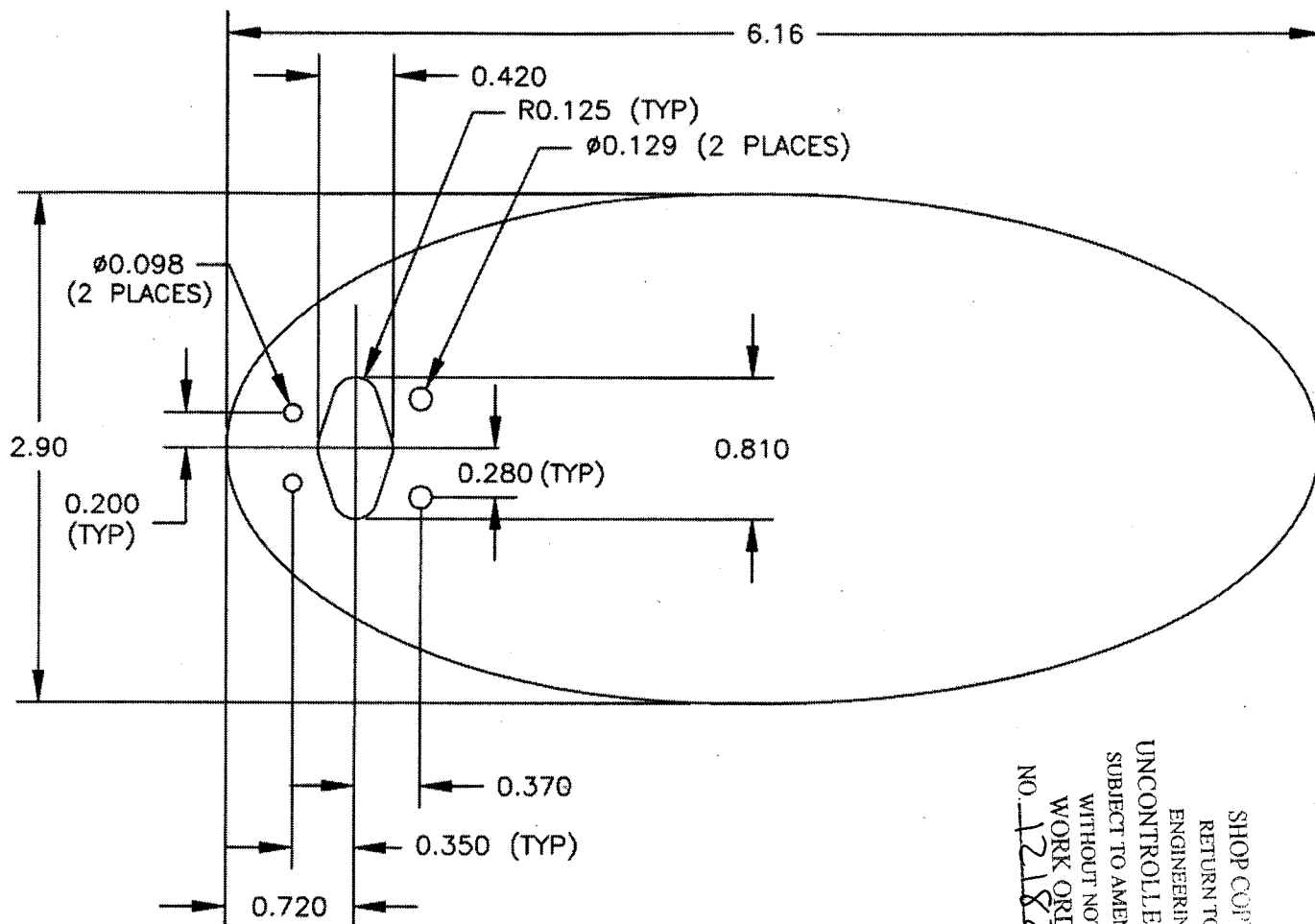
Location	Loc Qty	Loc Code
MAT021	249.61	
m126309	130.52	
m126350	9.34	
m128903	109.75	
TPI	58.866	
m129439	58.866	
130530		

4.66



DESIGN UP	DRAWN BY UP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3285	REV. A SHEET 1 OF 1
DATE 04.05.08		TITLE CAP	SCALE 1:1
A	04.05.08	NEW ISSUE	

RELEASED
04.06.22



D3285-1 CAP

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32 (QQ-A-250/8) 0.080 THICK
- 2) ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121820 JLS
14-07-04

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